

Date: Wednesday, 11/03/2009 12:59:57 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : HELI-ACCESS STEP RH (FOLDING)
 Job Number : 46456
 Estimate Number : 12568
 P.O. Number :
 This Issue : 11/03/2009 S.O. No. :
 Prsht Rev. : NC Part Number : D412630034
 First Issue : / / Type : LARGE FAB ASSY Drawing Number : IIN D412-630
 Previous Run : 46298 Project Number : N/A
 Material :
 Due Date : 27/03/2009 Qty: 360 Um: Each
 Written By :
 Checked & Approved By : JUD 09-03-11
 Comment : Est. Rev:A New Issue 06-11-08 JLM
 est rev B ecn1019, added D2807-041 EC verified by:DD
 Est RevC 09-03-02 as per rev.m DD verifeid by:ec

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



JUD 09/04/01



Comment: DOCUMENT CONTROL

Photocopy bluefile & create labels per PPP D412-630-034 CHG003

5 09/04/01

2.0 D2012107 Clevis



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Clevis

Pick:

Qty	Part Number	Description
1	D2012-107	Clevis

Batch

4 5074

JUD 09/03/24 X3

3.0 D2803042 Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bracket Assembly

Pick:

Qty	Part Number	Description
1	D2803-042	Bracket Assembly RH

Batch

41673 x1

JUD 09/03/24 X3

4.0 D2804042 Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bracket Assembly

Pick:

Qty	Part Number	Description
1	D2804-042	Bracket Assembly RH

Batch

44551

JUD 09/03/24 X3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Job Number: 46456

Part Number: D412630034

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D2807041

Door prop



Comment: Qty.: 2.0000 Each(s)/Unit Total: ~~4.0000~~ 6.0000 Each(s)

Support Prop

Batch:

34485812

43901

500

8809103/24 (X3)

6.0

D2813

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: ~~4.0000~~ 6.0000 Each(s)

Washer

Pick:

Qty

Part Number

Description

Batch

2

D2813

Washer

41667x4 B4632x2

8809103/24 (X3)

7.0

D3562042

Step Assembly, RH



Comment: Qty.: 1.0000 Each(s)/Unit Total: ~~2.0000~~ 3.0000 Each(s)

Step Weldment LH

Pick:

Qty

Part Number

Description

Batch

1

D3562-042

Step Weldment RH

46682

8809103/24 (X3)

8.0

D33951

Bushing



Comment: Qty.: 4.0000 Each(s)/Unit Total: ~~8.0000~~ 12.0000 Each(s)

Bushing

Pick:

Qty

Part Number

Description

Batch

4

D3395-1

Bushing

46435

8809103/24 (X3)

9.0

AN3C21A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total: ~~4.0000~~ 6.0000 Each(s)

BOLT

Pick:

Qty

Part Number

Description

Batch

2

AN3C21A

Bolt

1169148

8809103/24 (X3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 46456

Part Number: D412630034

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

AN8C16

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : ~~2~~ 4.0000 Each(s)

Bolt

Pick:

Qty Part Number

Description

Batch

2 AN8C16

Bolt

M105969

109569

SS 09/03/24 (X3)

11.0

AN310C8

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : ~~2~~ 4.0000 Each(s)

Nut

Pick:

Qty Part Number

Description

Batch

2 AN310C8

Nut

M109148

SS 09/03/24 (X3)

12.0

MS24665302

Cotter Pin



Comment: Qty.: 2.0000 Each(s)/Unit Total : ~~2~~ 4.0000 Each(s)

Cotter Pin

Pick:

Qty Part Number

Description

Batch

2 MS24665-302

Cotter Pin (or AN380C3-4)

M106763

SS 09/03/24 (X3)

13.0

NAS1515H3

Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total : ~~6~~ 12.0000 Each(s)

Washer

Pick:

Qty Part Number

Description

Batch

6 NAS1515H3

Washer

M109200

SS 09/03/24 (X3)

14.0

NAS1515H5L

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : ~~4~~ 8.0000 Each(s)

WASHER

Pick:

Qty Part Number

Description

Batch

4 NAS1515H5L

Washer

M108904

SS 09/03/24 (X3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Drawing Name: HELI-ACCESS STEP RH (FOLDING)

Job Number: 46456

Part Number: D412630034

Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

NAS1515H8

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)
Washer

Pick:

Qty	Part Number	Description
4	NAS1515H8	Washer

Batch

M109430 x7

M111275 (52)
8/8/09/04/08

16.0

MS210433

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)
Nut

Pick:

Qty	Part Number	Description
4	MS21043-3	Nut

Batch

M110562

8/8/09/03/24 x 3

17.0

MS24693C280

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)
Screw

Pick:

Qty	Part Number	Description
2	MS24693-C280	Screw (or MS24694-C565)

Batch

M101390

8/8/09/03/24 x

18.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble as per dwg D412-630 p.14

Coat all hardware with LPS3 rust inhibitor
A/R LPS3 batch: M109929

COAT exposed HARDWARE WITH LPS PROCYON.

A/R LPS PROCYON

BATCH:

M104251

8/8/09/03/31 (3)

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8/8/09/03/31 (x3) R40

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Drawing Name: HELI-ACCESS STEP RH (FOLDING)

Job Number: 46456

Part Number: D412630034

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

21.0

D28061

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total: ~~2~~⁶ 0000 Each(s)

Bushing

Pick: Packing Kit

Qty Part Number
2 D2806-1

Description
Bushing

Batch

42174

SS 09/03/31 (X3)

22.0

D28063

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total: ~~2~~⁶ 0000 Each(s)

Bushing

Pick: Packing Kit

Qty Part Number
2 D2806-3

Description
Bushing

Batch

42175

SS 09/03/31 (X3)

23.0

D28105

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total: ~~2~~³ 0000 Each(s)

Strut

Pick: Packing Kit

Qty Part Number
1 D2810-5

Description
Strut

Batch

44552

SS 09/03/31 (X3)

24.0

D33961

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: ~~2~~⁶ 0000 Each(s)

Spacer

Pick: Packing Kit

Qty Part Number
2 D3396-1

Description
Spacer

Batch

AB41670

SS 09/03/31 (X3)

25.0

AN4C6A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: ~~2~~³ 0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number

Description

Batch

M169147

SS 09/03/31 (X3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP RH (FOLDING)

Job Number: 46456

Part Number: D412630034

Job Number:



Seq. #:

Machine Or Operation:

Description :

1 AN4C6A Bolt

26.0

AN4C10A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number

Description

Batch

1 AN4C10A

Bolt

M106302 x1

M104679 x2

8809103/31(x3)

27.0

AN4C15A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number

Description

Batch

2 AN4C15A

Bolt

M107082

8809103/31(x3)

28.0

AN44C7A

Eyebolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Eyebolt

Pick: Packing Kit

Qty Part Number

Description

Batch

1 AN44-C7A

Eyebolt

M100446

8809103/31(x3)

29.0

AN5C15A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number

Description

Batch

2 AN5C15A

Bolt

M109148

8809103/31(x3)

30.0

NAS1515H4

Washer



Comment: Qty.: 7.0000 Each(s)/Unit Total : 14.0000 Each(s)

Washer

Pick: Packing Kit

Qty Part Number

Description

Batch

7 NAS1515H4

Washer

M109267

8809103/31(x3)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP RH (FOLDING)

Job Number: 46456

Part Number: D412630034

Job Number:



Seq. #:

Machine Or Operation:

Description :

31.0

NAS1515H5

Washer



Comment: Qty.: 7.0000 Each(s)/Unit Total: ~~7~~ 4.0000 Each(s)

Washer

Pick: Packing Kit

Qty Part Number

Description

Batch

7 NAS1515H5

Washer

11109430

88 09/03/24 (X3)

32.0

MS210434

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: ~~4~~ 8.0000 Each(s)

Nut

Pick: Packing Kit

Qty Part Number

Description

Batch

4 MS21043-4

Nut

1111125

88 09/03/24 (X3)

33.0

MS210435

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total: ~~3~~ 6.0000 Each(s)

Nut

Pick: Packing Kit

Qty Part Number

Description

Batch

3 MS21043-5

Nut

11109053

88 09/03/24 (X3)

34.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

88 09/04/01 (X3) RHC

35.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-630-034

Location:

PPP Rev:

10

9/4/12

SP

36.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/08 (X3)

Job Completion



MF 09-04-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

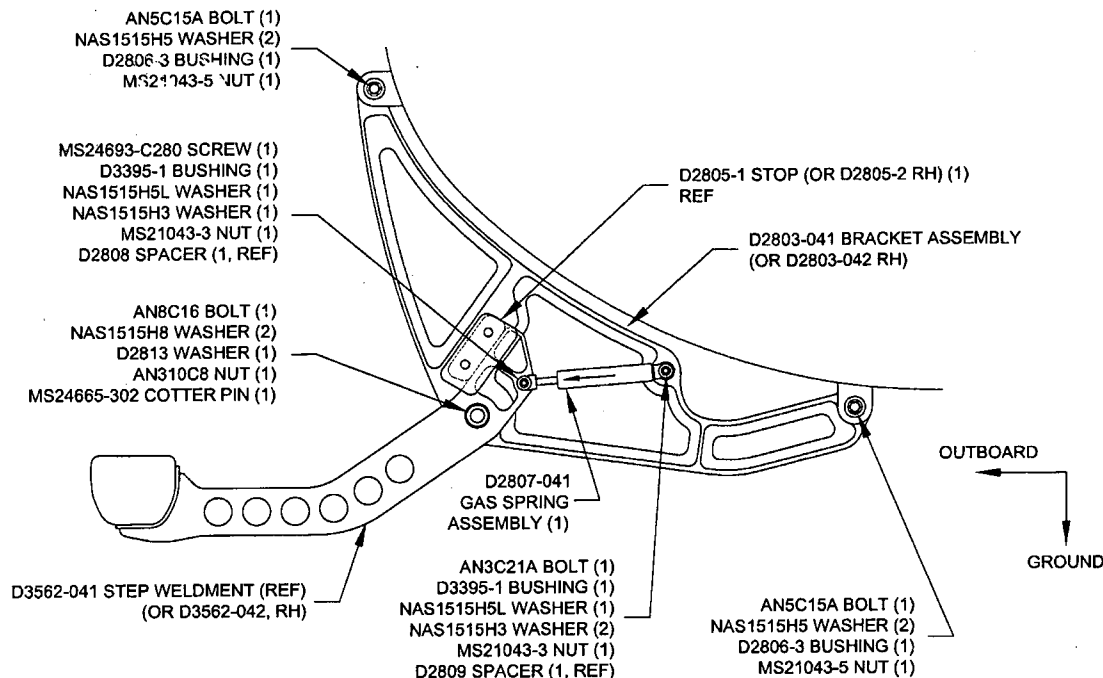
D412-630-033/-034 Heli-Access-Step™ Installation

FIGURE 14 – STA 84.29 for D412-630-033/-034 Heli-Access-Step™ Installation
(View rotated 90° CW)

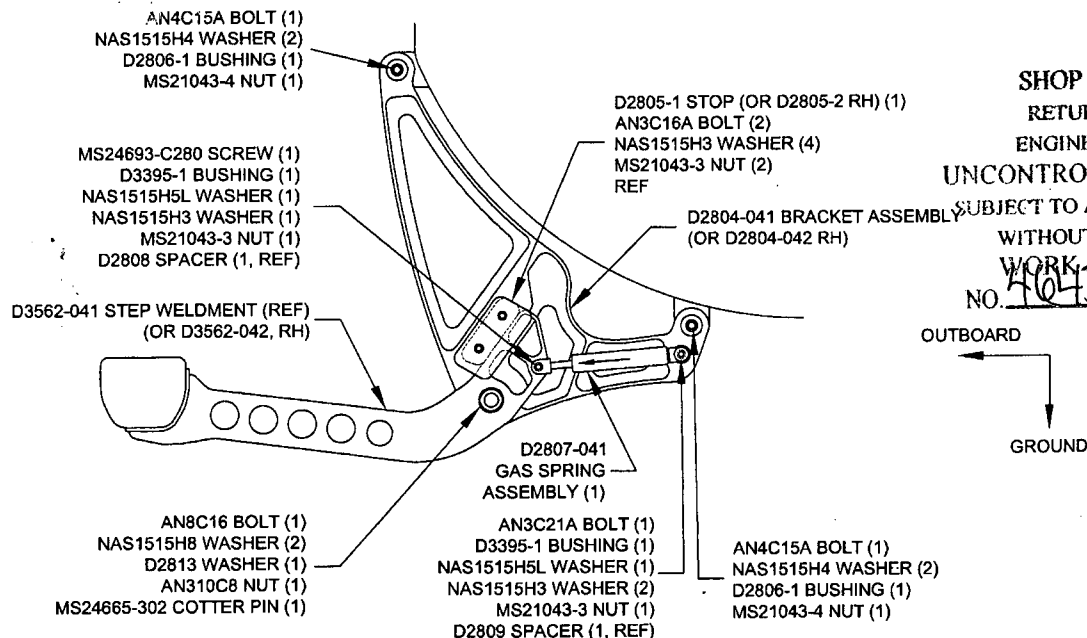


FIGURE 15 – STA 155.06 for D412-630-033/-034 Heli-Access-Step™ Installation
(View rotated 90° CW)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 46454

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Revision: M
Date: 08.12.12

Qty -033	Qty -034	Qty -243	Qty -244	Part Number	Description
X				D412-630-033	HELI-ACCESS-STEP™ LH (FOLDING)
	X			D412-630-034	HELI-ACCESS-STEP™ RH (FOLDING)
1		X		D412-630-243	STEP ASSEMBLY LH
	1		X	D412-630-244	STEP ASSEMBLY RH
		1	1	D2012-107	CLEVIS
		1		D2803-041	STA 84 BRACKET ASSEMBLY LH
			1	D2803-042	STA 84 BRACKET ASSEMBLY RH
		1		D2804-041	STA 155 BRACKET ASSEMBLY LH
			1	D2804-042	STA 155 BRACKET ASSEMBLY RH
2	2			D2806-1	BUSHING
2	2			D2806-3	BUSHING
		2	2	D2807-041	GAS SPRING ASSEMBLY (WAS D2807)
1	1			D2810-5	STRUT
		2	2	D2813	WASHER
		1		D3562-041	STEP WELDMENT LH
			1	D3562-042	STEP WELDMENT RH
		4	4	D3395-1	BUSHING
2	2			D3396-1	SPACER
		2	2	AN3C21A	BOLT
1	1			AN4C6A	BOLT
1	1			AN4C10A	BOLT
2	2			AN4C15A	BOLT
1	1			AN44-C7A	EYEBOLT
2	2			AN5C15A	BOLT
		2	2	AN8C16	BOLT
		2	2	AN310C8	NUT
		2	2	MS24665-302	COTTER PIN (OR AN380C3-4)
		6	6	NAS1515H3	WASHER
7	7			NAS1515H4	WASHER
7	7			NAS1515H5	WASHER
		4	4	NAS1515H5L	WASHER
		4	4	NAS1515H8	WASHER
		4	4	MS21043-3	NUT
4	4			MS21043-4	NUT
3	3			MS21043-5	NUT
		2	2	MS24693-C280	SCREW (OR MS24694-C565)

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Revision: M
Date: 08.12.12